

Work Order ID 79280 -2

January-24-12 1:27:22 PM

\*79280\*

Page 1

Item ID: D3564-3

Revision ID:

Item Name: Wearshoe

Start Date: 24/01/2012 Start Qty: 16.00

Required Date: 31/01/2012 Req'd Qty: 16.00

Reference:

Approvals: Process Plan: M.C.J.

QC:

Date: 12/01/24 Tooling:

Date: SPC (Y/N):

\*N900040100\*

Setup Start \*NS1\*

Stop \*NS2\*

Cust Item ID:

Customer:

Run Start \*NR1\*

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

Draw Nbr

Revision Nbr

D3564

Rev D

100

\*100\*

Waterjet

FLOW CNC Waterjet

FLOW WATER JET

0.00

Memo

0.00

1-Cut as per Dwg D3564 \*\*\*\*\* (D3564-1F) \*\*\*\*\* Dwg Rev: D Prog  
Rev: 1 2-Debur if necessary

B12-1-24

EC

110

\*110\*

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

B12-1-24

120

\*120\*

QC

Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

1 10 21 25 45

# Work Order ID 79280

January-24-12 1:27:22 PM

**\*79280\***

Page 2

Item ID: D3564-3

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Wearshoe

Start Date: 24/01/2012 Start Qty: 16.00

**\*16\***

Cust Item ID:

Required Date: 31/01/2012 Req'd Qty: 16.00

**\*16\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

130

NC BRAKE

0.00

**\*130\***

Brake NC

Memo

0.00

Brake NC

Deburr if necessary Form on Brake as per Dwg D3564 using Jigs DT8179 and DT8155 Form Joggle as per Dwg D3564 on brake using Jig DT8157

SB 12/01/25

20

140

QC5- Inspect part completeness to step on W/O

0.00

**\*140\***

QC

Memo

0.00

Quality Control

Ensure joggle as per dwg D3429

SB 12/01/25

(x3)

150

Large Fab

0.00

**\*150\***

Large Fab

Memo

0.00

Large Fab

Qty	Description	Batch/A/R
2059B	Hardcoat	

Weld hardcoat as per Dwg D3437

(3) MAL/E

12/01/25

# Work Order ID 79280

January-24-12 1:27:22 PM

**\*79280\***

Page 3

Item ID: D3564-3

Revision ID:

Item Name: Wearshoe

Start Date: 24/01/2012 Start Qty: 16.00

Required Date: 31/01/2012 Req'd Qty: 16.00

Reference:

Accept

**\*N9000040100\***

Setup Start **\*NS1\***

Stop **\*NS2\***

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

160

QC10- Inspect visual per QSI004- ground welds

0.00

**\*160\***

QC

Memo

0.00

Quality Control

8/12/12/25

170

QC5- Inspect part completeness to step on W/O

0.00

**\*170\***

QC

Memo

0.00

Quality Control

8/12/12/25

(X3)

180

Grey Sandtex(Ref.4.3.5.6) per QSI005 4.3

0.00

**\*180\***

Powdercoat

Powder Coating

Memo

START TIME: 3:45 OVEN TEMPERATURE:

FINISH TIME:

0.00

3200

4:15

3X Ø m-f 12/01/25

M118489

# Work Order ID 79280

January-24-12 1:27:22 PM

**\*79280\***

Page 4

Item ID: D3564-3

Revision ID:

Item Name: Wearshoe

Start Date: 24/01/2012 Start Qty: 16.00

Required Date: 31/01/2012 Req'd Qty: 16.00

Reference:

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Stop **\*NS2\***

Cust Item ID:

Customer:

Approvals: Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start **\*NR1\***

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan  
Code Accept Reject Reject Insp.  
Qty Qty Number Stamp

190

QC3- Inspect Part Finish

0.00

**\*190\***

QC

Memo

0.00

Quality Control

3 BR 12-1-25.

200

Identify as per dwg & Stock Location: \_\_\_\_\_

0.00

**\*200\***

Packaging

Memo

0.00

Packaging

12/1/25 sl 30

210

QC21- Final Inspection - Work Order Release

0.00

**\*210\***

QC

Memo

0.00

Quality Control

12/1/26 DJ

me  
12-01-26

# Picklist Print

January-24-12 1:27:26 PM

Page 1

Work Order ID: 79280

\*79280\*

Parent Item: D3564-3

\*D3564-3\*

Parent Item Name: Wearshoe

Start Date: 24/01/2012

Required Date: 31/01/2012

Start Qty: 16.00

Required Qty: 16.00

Comments: IPP Rev:A New Issue 07-03-08 ee  
IPP Rev:B As per Rev C 07-07-09 JLM  
IPP Rev:C As per Rev D 07-09-09 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased		No		100	sf	99.8300	1.1	18.52632	22		
								**					
											18.12-1-2012		

\*M304S16GA\*

304/316 Sheet .063

Location

Loc Qty

Loc Code

MAT020

99.83

119653

39.83

120243

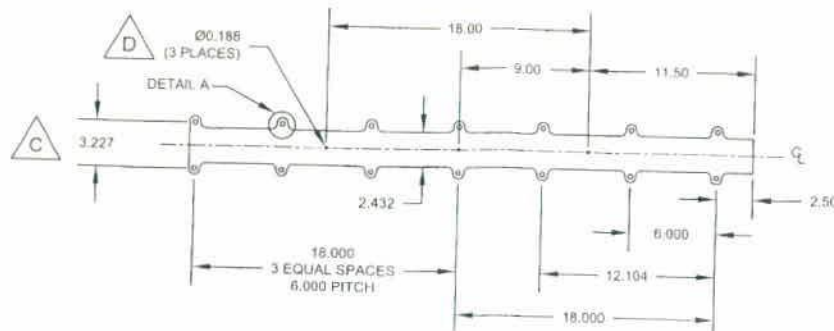
60

119653

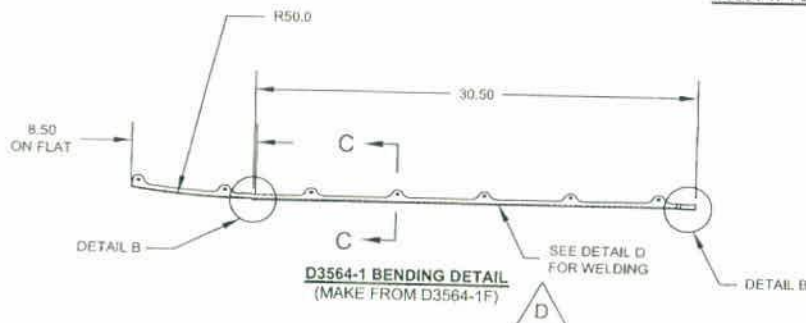
(24)



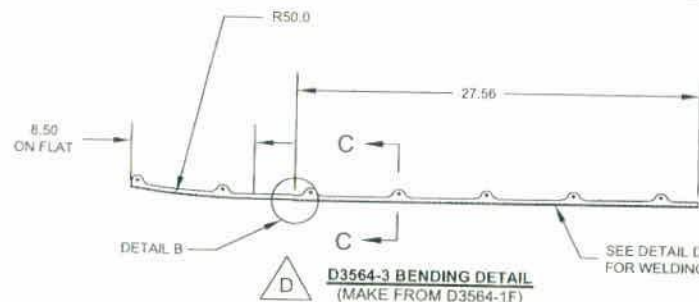




D3564-1F FLAT PATTERN



D3564-1 BENDING DETAIL  
(MAKE FROM D3564-1F)



D3564-3 BENDING DETAIL  
(MAKE FROM D3564-1F)

**D3564-1/-3/-5/-7/-9/-11/-13/-15 WEARPLATE NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)  
(REF DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: SEE TABLE IN ZONE A3
- 8) WELD PER DART QSI 004
- 9) SEE PG 3 FOR SECTIONS AND DETAILS
- 10) PARTS ARE SYMMETRIC ABOUT C

WEIGHTS:	
D3564-1	1.85 lbs
D3564-3	1.85 lbs
D3564-5	1.93 lbs
D3564-7	1.26 lbs
D3564-9	1.85 lbs
D3564-11	1.85 lbs
D3564-13	0.38 lbs
D3564-15	0.80 lbs

UPDATE DRAWING TEMPLATE: CHANGE ALL (TYP X PLS) TO (X PLACES); PG1 A8: UPDATE NOTES; PG1 B6,B3: D3564-1/-3 WAS ONE FIGURE; PG2 A7,A3: D3564-9/-11 WAS ON PG1; PG3 B8,C8: D3564-13 WAS ON PG2; PG3 D2: WELDING DETAIL WAS ON PG1 PG3 A5,7,B2: RELOCATE DETAILS AND SECTION; PG3 A5,7,B2: INCREASE DETAIL AND SECTION SIZE		CB	07.08.21
C	MOVE TAB OUTBOARD, DETAIL A	PH	07.04.17
B	ADD AMS 5513 AND AMS 5524	PH	07.03.20
A	NEW ISSUE	PH	06.12.18
REV	DESCRIPTION	BY	DATE
DESIGN	PH		
DRAWN	CB		
CHECKED	PH		
MFG. APPR.	PH		
APPROVED	PH		
DE APPR.	PH		
DATE	07.08.21		

<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3564	REV. D SHEET 1 OF 3
TITLE WEARSHOE	SCALE 1:8

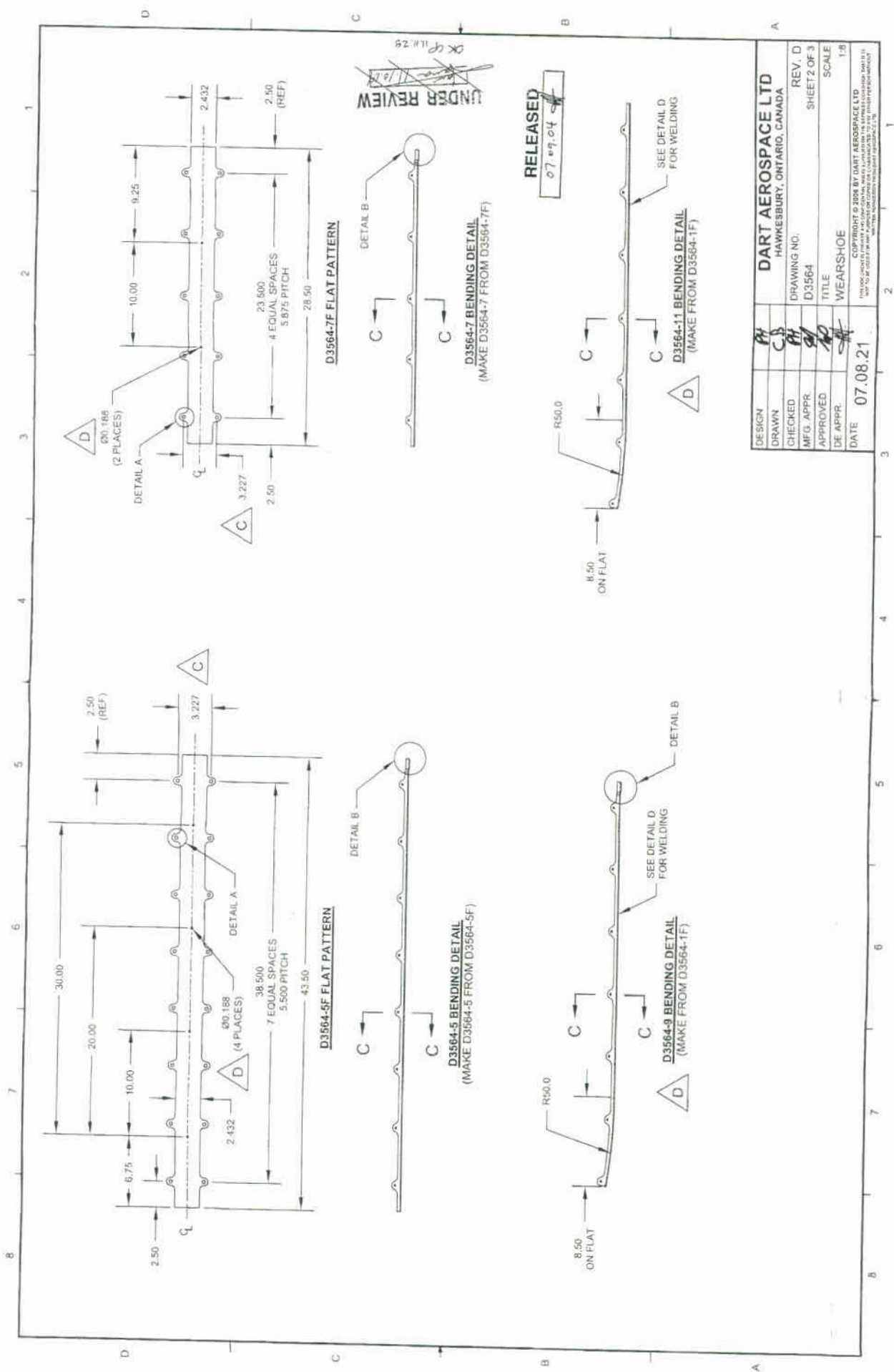
COPYRIGHT © 2006 BY DART AEROSPACE LTD  
THIS DOCUMENT IS UNCLASSIFIED AND UNCONTROLLED. IT IS THE PROPERTY OF DART AEROSPACE LTD. IT IS TO BE USED FOR ANY PURPOSE OR FOR ANY OTHER PERSON OR ENTITY WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.

RELEASED  
07.09.04

UNDER REVIEW  
11/04  
First change  
OK 11-11-28

79280 H65  
12/31/24

79280

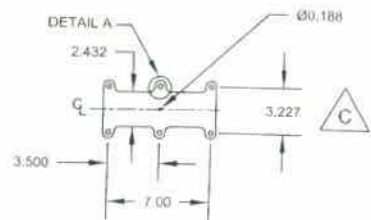


DESIGN	HA	DART AEROSPACE LTD
DRAWN	CS	HAWKESBURY, ONTARIO, CANADA
CHECKED	HA	DRAWING NO.
MFG. APPR.	HA	D3564
APPROVED	HA	TITLE
DE APPR.	HA	WEARSHOE
DATE	07.08.21	SCALE
		1:8

COPYRIGHT © 2004 BY DART AEROSPACE LTD  
THIS DOCUMENT IS UNCLASSIFIED AND IS NOT TO BE RELEASED TO THE PUBLIC WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD



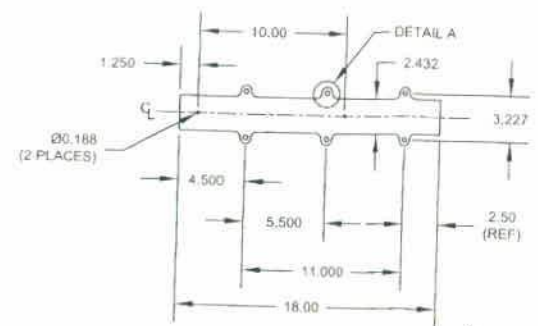
79200



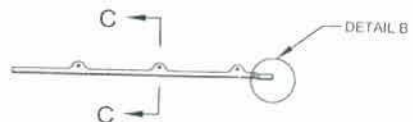
**D3564-13F FLAT PATTERN**



**D3564-13 BENDING DETAIL**  
(MAKE D3564-13 FROM D3564-13F)



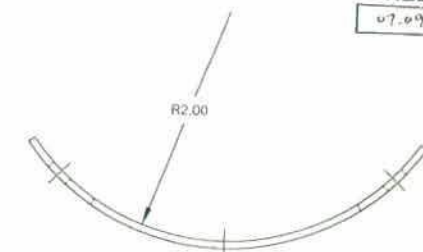
**D3564-15F FLAT PATTERN**



**D3564-15 BENDING DETAIL**  
(MAKE D3564-15 FROM D3564-15F)



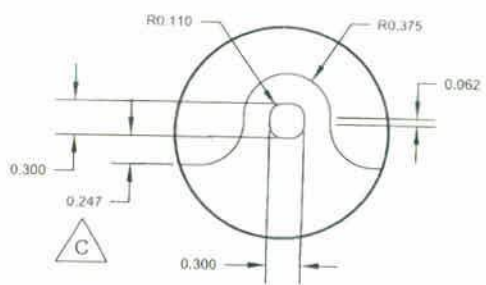
**DETAIL D**  
(D3564-1/-3/-9/-11 WELDING DETAIL)



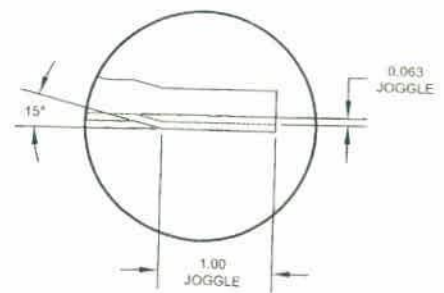
**SECTION C-C**  
SCALE 1:1

RELEASED  
07.07.04

UNDER REVIEW  
07.11.28



**DETAIL A**  
SCALE 1:1



**DETAIL B**  
SCALE 1:1

DESIGN	PH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	CB		
CHECKED	PH	DRAWING NO.	REV. D
MFG. APPR.	PH	D3564	SHEET 3 OF 3
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	WEARSHOE	1:8
DATE	07.08.21	COPYRIGHT © 2006 BY DART AEROSPACE LTD	